

GREEN

Date: Thursday, 4/26/2007 3:34:03 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG	
Job Number	: 32080		Part Number	: D25941	
Estimate Number	: 10178		Drawing Number	: D2594 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/26/2007 S.O. No. : N/A		Drawing Revision	: C	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/30/2007	
Previous Run	: 31109		Qty:	160	Um: Each
Written By			T2est		
Checked & Approved By					
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
Comment: Qty.: 0.0547 f(s)/Unit Total : 8.7528 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch <u>1104489</u> <u>7/05/24</u> <u>162</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1		
		<u>112</u> <u>07-05-28</u> <u>162</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: PLUG
Job Number: 32080		Part Number: D25941
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING 	POWDER COATING 20104476  162X
Comment: POWDER COATING — Powder Coat - OLIVE DRAB GREEN — <i>BR/Mh</i> 07/05/28. (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)		
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>FL</i> 07/05/28 162
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>m-l</i> 07/05/28 162X
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>EP-16</i>		
9.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>07/05/29</i> 162
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>07/05/29</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD	Work Order:	32080
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>Amber</u>	Audited by:	<u>J.F</u>	Prototype Approval:	N/A
Date:	<u>07/05/24</u>	Date:	<u>07/05/24</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	

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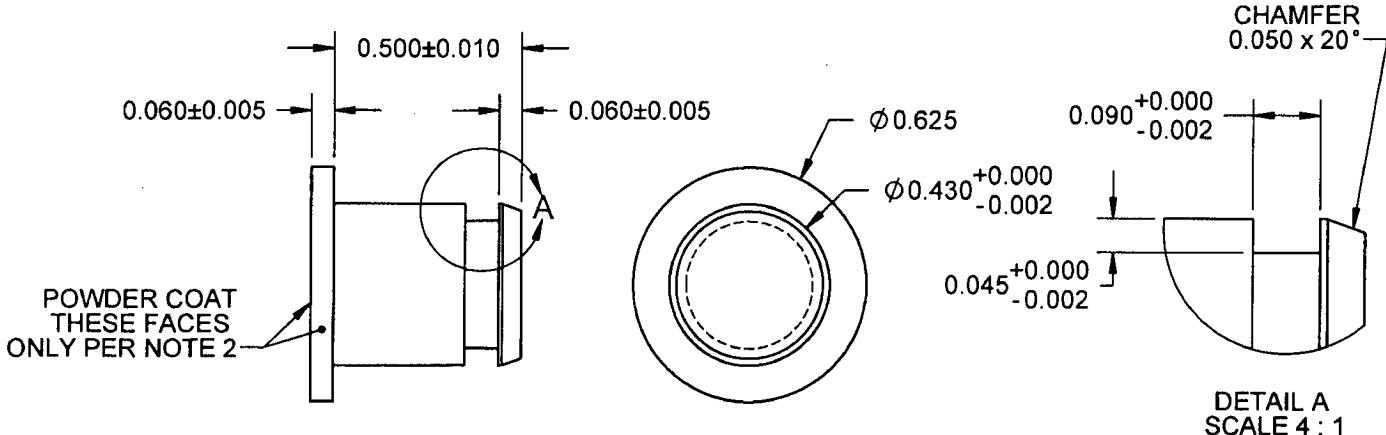
DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594	REV. C	SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE 2:1	

REVIEWED BY

06.11.28 *CH*

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE



D2594-1 PLUG

D2594-1 PLUG NOTES:

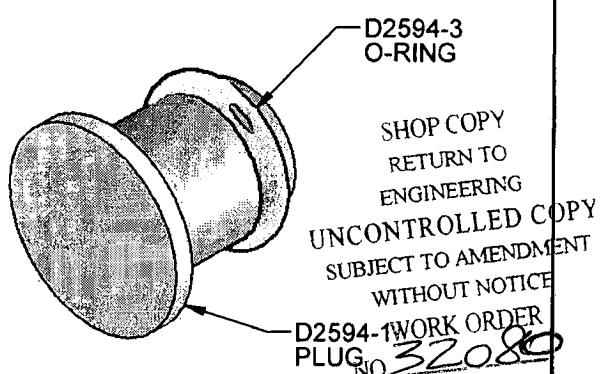
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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